

Work Order ID 50028

July 6, 2009 7:39:29 AM

split



Page 1

Item ID: D3826-041 *1*

Accept



Setup Start



Revision ID: B

Stop



Item Name: Rib / Gusset Assembly

Start Date: 08/07/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 17/07/2009 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3826

Rev B

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- use DT9434 to assemble D2325 support gusset together
2- locate D2325 on rib and weld as per dwg D3826
A/R ER316 S.S. Rod
Batch: *H108160 /*

PD 09.07.14 (2)

110

0.00



QC9- Inspect visual per QSI004- Fusion Welds

PC 09.07.15

QC

Memo

0.00

Quality Control

120

0.00



QC5- Inspect part completeness to step on W/O

=> 8 09/07/15

QC

Memo

0.00

Quality Control

(12) f

Work Order ID 50028



Page 2

July 6, 2009 7:39:29 AM

Item ID: D3826-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Rib / Gusset Assembly

Start Date: 08/07/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 17/07/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: Basket

0.00



Packaging

Memo

0.00

PD 09-07-15 (2)

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/15 [Signature]

MF 09-07-15

Picklist Print

Page 1

July 6, 2009 7:39:28 AM

Work Order ID: 50028

Parent Item: D3826-041RevB

Parent Item Name: Rib / Gusset Assembly

Comments:

Start Date: 08/07/2009

Required Date: 17/07/2009

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2235-1RevB1		Manufactured	No				Each	7.0000	6.0000			
Basket Rib												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST ~~48665~~ B50029 → 7 → 3
48665 → 7 → 3 SAD 09-07-10 Qty 6

D3929-041RevA		Manufactured	No				Each	4.0000	6.0000			
Gusset Assembly												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 4
47273 1
48663 3 → 3
50063 → 3 Each 5.0000 6.0000 SAD 09-07-10 Qty 6

D3929-042RevA		Manufactured	No				Each	5.0000	6.0000			
Gusset Assembly												

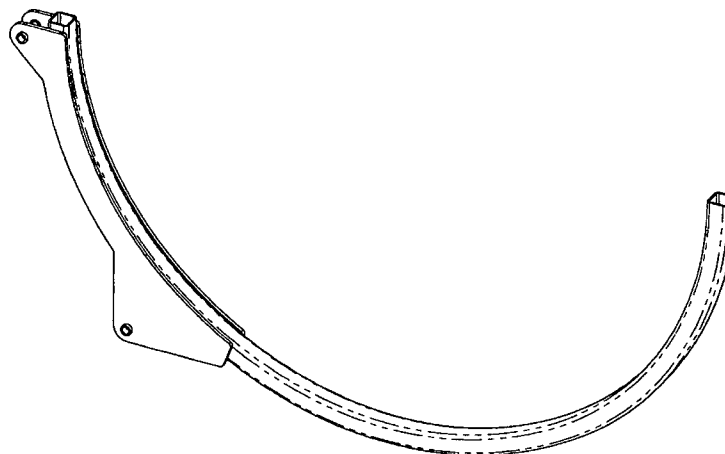
Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 5
47959 2
48662 3 → 3
50062 → 3 SAD 09-07-10 Qty 6

ITEM	QTY. -041	P/N	DESCRIPTION
1	X	D3826-041	RIB/GUSSET ASSY
11	1	D2235-1	RIB
12	1	D3929-041	GUSSET ASSEMBLY
13	1	D3929-042	GUSSET ASSEMBLY

△B



D3826-041 RIB/GUSSET ASSY

50028

RELEASED
8/24/12

B	D3929-041/-042 WERE D2325 (ZN D3-1 & ZN D6-2); UPDATED WEIGHT (ZN A8-1). REASON: SEE NCR#08-042.	MB	09.04.16
A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.04.16		

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 3.32 lbs

△B

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3826 REV. B
SHEET 1 OF 2
TITLE RIB/GUSSET ASSY SCALE NTS

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8 7 6 5 4 3 2 1

D

D

 D3929-042
GUSSET ASSEMBLY

 D3929-041
GUSSET ASSEMBLY

TYP

C

C

0.250

B

B

D2235-1
RIB







D3826-041 RIB/GUSSET ASSY

50028

RELEASED
2/24/12

A

A

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. B
CHECKED		D3826	SHEET 2 OF 2
MFG. APPR.		TITLE	SCALE
APPROVED		RIB/GUSSET ASSY	NTS
DE APPR.		DATE 09.04.16 <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1